

**D5610-1 AFT X-TUBE (EC130)**

RELEASED

2019 OCT 10  
EN 14-923

**NOTES:**

- 1) MATERIAL: MAKE FROM D5610-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 30.9 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE
- 9) MAX AMPLITUDE OF RIPPLING ALONG BENT PORTION OF THE TUBE IS 0.030.
- 10) MAX TWIST: WITH TUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN THE CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38
- 11) MAX TUBE CRUSHING DUE TO BENDING 2%
- 12) MAX TUBE CRUSHING DUE TO BENDING 3.5%
- 13) AT A TRIMMED HEIGHT OF 15.45, REQUIRED OVALITY DIMENSION Dmax = 3.435 - 3.480

APPROVED

C	ADDED CRUSHING CALCULATION, INCREASE CRUSHING ALLOWANCE ON OUTER BENDS (3.5% WAS 2%), ADDED DMAX TOLERANCE FOR INDICATED LOCATIONS	ZF	19.09.05
B	D5610-1: ADDED OUTER BENDS AND TRIM ENDS, REMOVED SECTION A-A D5610-3: DELETED Ø0.395 HOLES FOR SADDLES, SECTION C-C CSINK HOLES QTY 4 WAS QTY 6, DIM 0.935 WAS 0.875, 2.805 WAS 2.932	ZF	19.01.04
A	NEW ISSUE	ZF	18.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	<b>D5610</b>	SHEET 1 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>AFT X-TUBE (EC130)</b>	NTS
DATE	19.09.05	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D

C

B

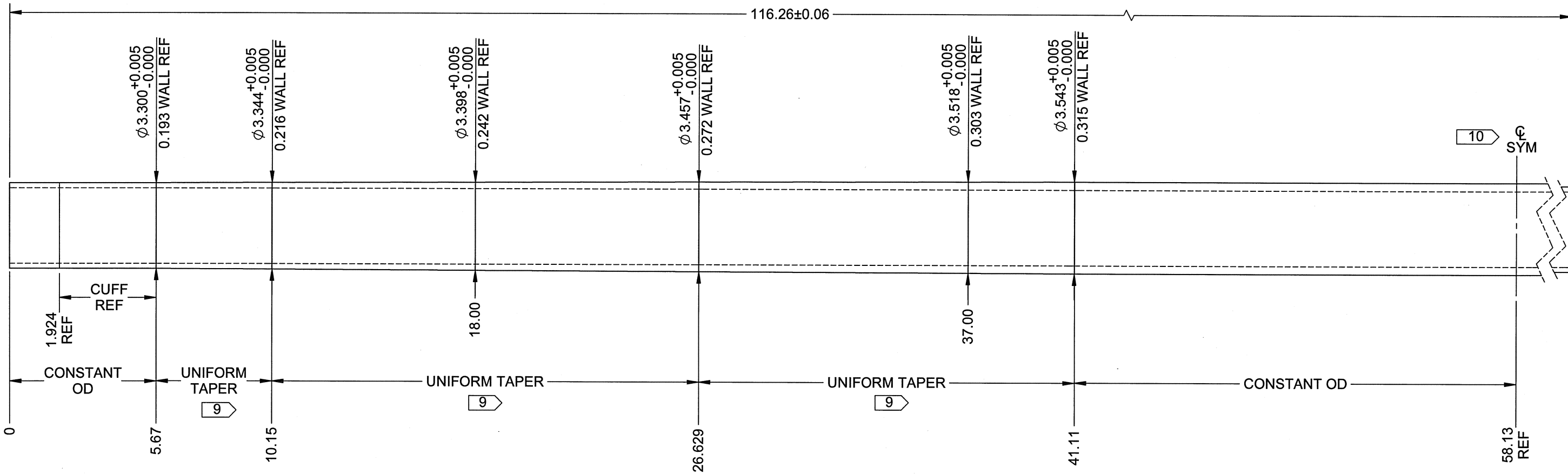
A

D

C

B

A



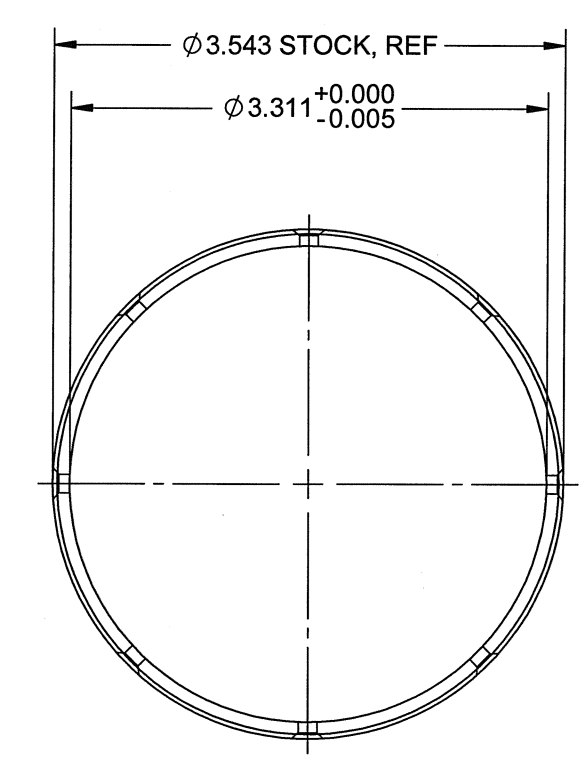
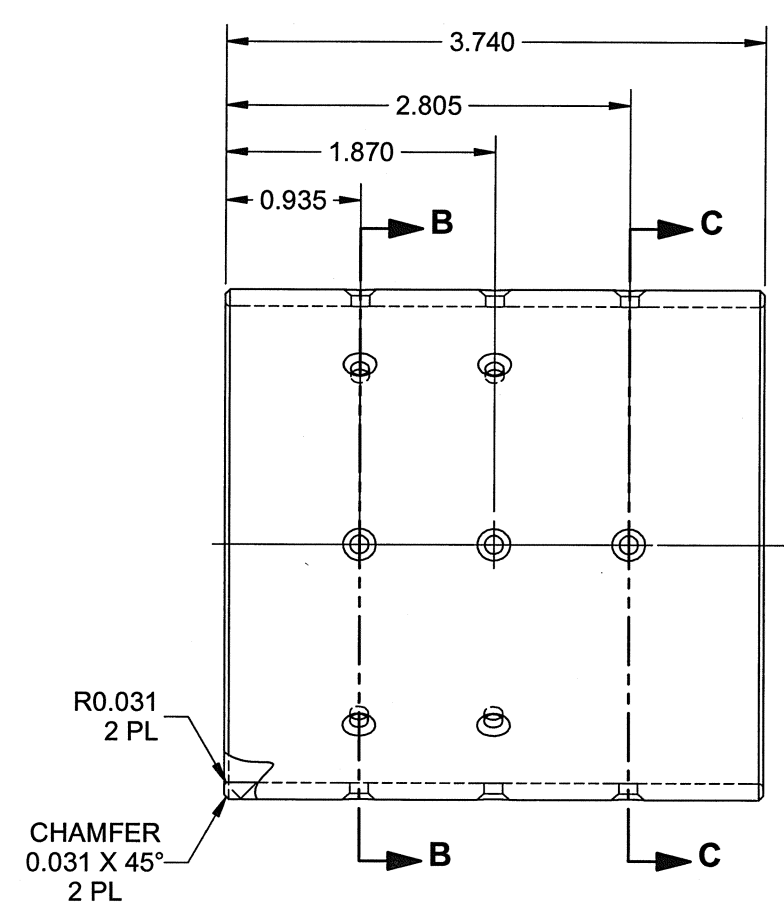
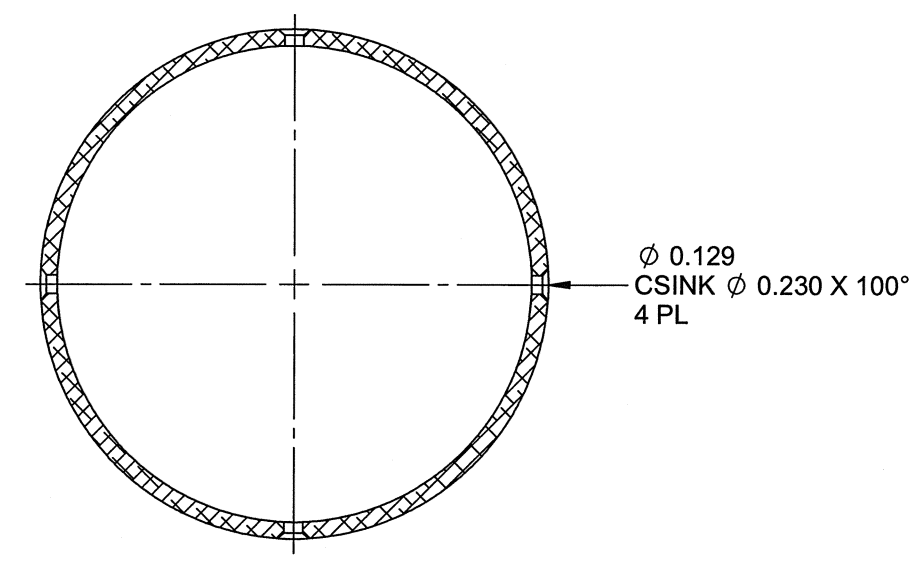
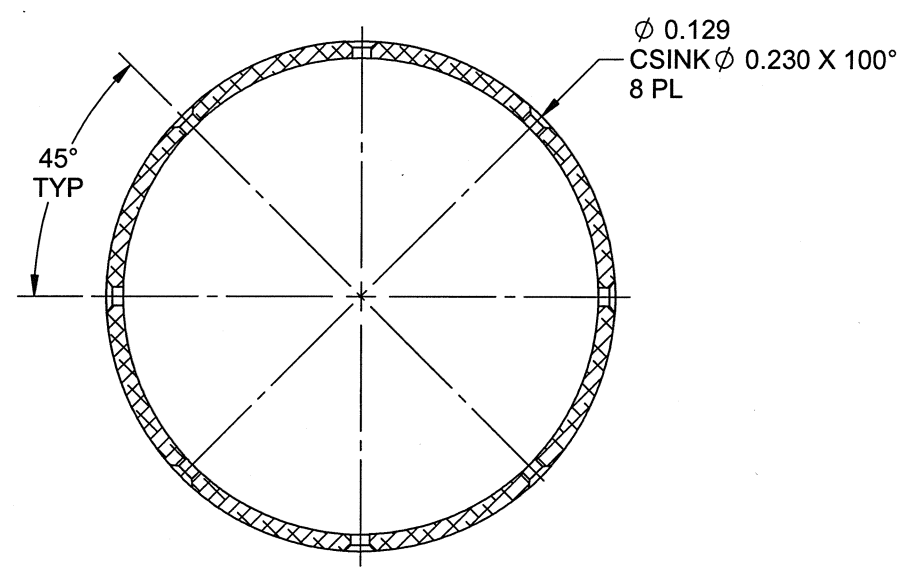
**D5610-1TRN TURNED TUBE**

- NOTES:
- 1) MATERIAL: MAKE FROM D6030-140
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 31.7 lbs
  - 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE
  - 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. ALL TRANSITIONS SHOULD BE SMOOTH R50 MINIMUM.
  - 10) PART SYMMETRICAL ABOUT CENTER LINE

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DESIGN	NO	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	<b>D5610</b>	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>AFT X-TUBE (EC130)</b>	NTS
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**D5610-3 CUFF**

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- NOTES:**
- 1) MATERIAL: MAKE FROM D6030-140
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.47 lbs

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CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	<b>D5610</b>	SHEET 3 OF 3
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